

CHEMLINQ™ MCL-T20

Melamine Cleaning Compound



- Excellent Cleaning Efficiency
- Ideal for High-Precision Industries (Electronics and Automotive)
- Enhanced Mold Lifespan and Minimized Downtime

CHEMLINQ MCL-T20 is a mold cleaning compound tablet composed of melamine resin, silica filler, and other additives. It cleans metal mold dies for transfer molding processes by effectively removing organic and inorganic residues and stains. It also restores mold surfaces to ensure consistent mold quality and extend the operational lifespan of molds. Overall, **MCL-T20** is ideal for industries requiring precision and reliability in molding processes.

MCL-T20 can be used alone or partnered with CHEMLINQ™ RCS rubber cleaning sheet series to enhance cleaning performance.

Specifications

Property	Value	Unit
Appearance	White, cylindrical tablets	
Specific Gravity	1.60	–
Compression Ratio	75	%
Spiral Flow	22	in
Gel Time	17	s
Hot Hardness (120 seconds)	84	Shore D
Flash (50/20/15/10/5 µm)	1.2/2.0/2.1/2.6/5.0	mm

Recommended Molding Parameters

Mold Type	Preheat Settings	Mold Temperature	Transfer Pressure	Transfer Time	Curing Time	Shots
Auto-mold	0–10 s	160–190 °C	90–100 kg _f /cm ²	8–25	4–10 min	Up to 3 shots
Conventional Mold	90–110 °C	160–190 °C	30–140 kg _f /cm ²	20–40	5–15 min	

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Preparation

Instructions

1. Ensure the mold temperature is appropriate for cleaning, typically around the operating temperature of the mold. Make sure the mold is free from any significant debris or loose contaminants.
2. Place the MCL-T20 tablets into the mold cavity. The number of tablets depends on the size of the mold and the level of contamination.
3. Close the mold and initiate a standard transfer molding cycle. This includes applying the necessary pressure and heat to activate the cleaning compound. The heat and pressure help the MCL-T20 tablets to flow across the mold surfaces, effectively loosening and removing organic and inorganic residues.
4. After the cycle is complete, open the mold and eject the cleaning compound residue. Inspect the mold for any remaining contaminants. If necessary, repeat the process using additional tablets or in combination with other cleaning methods, such as CHEMLINQ™ RCS rubber cleaning sheets.
5. Perform a final inspection to ensure all residues are removed.

Storage

and

Handling

1. The cleaning compound is sealed in PE bags, with 10 kg per carton.
2. Ensure the product stays dry, as high humidity can cause curing failures in the cleaning compound. Keep the product away from heat sources, as excessive heat can make the cleaning compounds ineffective.
3. Store the product below 25 °C. If taken from a cold room or refrigerator, thaw it in the sealed package for 18 to 24 hours until it reaches room temperature.
4. The shelf life is 6 months if stored at temperatures ≤ 25 °C and 12 months at temperatures ≤ 10 °C.

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